Work Order ID 106453

106453

Page 1

September-05-1	13 8:08:42 AN	М					
Item ID:	D2938-1	•		Accept	*N900040100	* Setup Sta	*NS1*
Revision ID:		0.11		<u>.</u>		Sto	^{op} *NS2*
Item Name:	206 Saddle Lo	eft side					IND /
Start Date:	8/30/13	Start Qty: 3.00	*3*		Cust Item ID:		• • •
Required Date	: 9/20/13	Req'd Qty: 3.00	*3*		Customer:		
Reference:					\X\V	- 01	///
Approvals:	Process Pla	an:	Date:	Tooling:	Dare:	Run Sta	"NRT"
	QC:	1	Date:	SPC (Y/N):	Date:	Ste	" *NR2*
Sequence ID/ Work Center l	ID	Operation Description		Set Up/ Run-Hours	Tool ID Tool # Plan	Accept Reject Qty Qty	Reject Insp. Number Stamp
Draw Nbr	Re	vision Nbr					
D2938	Rev	/ C					***
*100 *100* HAAS I HAAS CNC vertic	cal machine #1	inspect as	art number and batch hun e programmed correctly.2 per dwg D2938 & attache nd visually inspect as per	9.00 9.00 bery Inspect part number Machine Step No 1 of F d Dimension Sheet 3-Mac	er and batch	T 13.	09-16 PHO
110 *110* Mill Conv		CONVENTIONAL MI	LLING MACHINE	0.00		4 13-	09-16
Conventional Mill	ing Machine	N	Keyway and inspect per at	ached dimension sheet			
			- ;	. *			
120	•	QC1- Inspect dimension	ons to dimension sheet	0.00		$\sim t$	7
120		Memo		0.00		27 13	09 16 (x
Ouality Control							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

-61		•	∀ €
DQA: ANT	Date:		_
111	- 13/18tz	13	
A Closed:	Date: 37	11/23	·

								· · · · · · · · · · · · · · · · · · ·	QA Closed.	- Dute.	1)/10/20		
Work Order: 10(4453					DISPOSITION			AGAINST DE	DEPARTMENT/PROCESS				
Part No.	13-	293	8-1		Scrap Y Machining Y Small Fa Use-as-is Thermoforming Finishin			Crosstube Small Fab Finishing Composite	b Prod. Eng. Coor. Quality g Rec/Store/Packaging Other				
Root	Description of work order upd					Initial	Ac	tion					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Sign & Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	3-9-16	(60	χl	bent of will et . 312" . 323"	deill .312" of off center in over sized sleid belt holes to ein not note to	9 13/9/16	SRAP.	591 UBH!	13.09.1C	JL 13-9-16	DAS 16 9-89		
				····	F.A	ULT CATI			<u> </u>	•			
Landing	Gear				General								
	Bending Centre No Cracks	t Concei	ntric to	o/s	Bend BOM/Route Broken/Damaged	Grain Hardw Inspec	are ion Incomplete		Ovalized Over/Under Part Incorred		Pressure/Forced Temperature/Cure Weld		
	Crushed/C	rimped			Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination	Maint	enance		Part Moved				
	Heat Trea	t			Countersink	Mislab	eled		Positioned V		- (\)		
	Inspection	•	Tube		Cut Too Short	Misrea	d	<u>L</u>	Power Loss/	Surge 7	Other deil		
	Ripples in			<u> </u>	Drill Holes	Offset bit bent of offse							
	Torque W			n _	Drawing	Out of Calibration							
	Turning Se			<u> </u>	Finish		Sequence						
	Wave/Twi	st in Tul	oe	,	Folio	Outside Dimensions							

Hand Finishing

106453

Page 2

September-05-1.	3 8:08:42 A	M			. /()4+				,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
Item ID: Revision ID: Item Name:	D2938-1 206 Saddle L	eft side		Accept	*	N900	040	100)* s	etup Sta	1/1	S1* S2*
Start Date: Required Date: Reference:	8/30/13 9/20/13	Start Qty: 3.00 Req'd Qty: 3.00	*3*			Cust Item II Customer:) :		_	S.A.		
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		Da	te: te:		ł	tun Sta Sta		R1* R2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - second	nd check	Set Up/ Run Hou 0.00	urs D-A	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp AS 08 9-89
140 *111		Chemical Conversion Co	at per QSI005 4.1	0.00					3	.74	13-	348

				DQA:	Date:	_
NCR: Yes / No	WORK ORDER NON-COI	NFORMANCE / U		QA Closed:	Date:	
Work Order:	DISPOSITION		AGAINST DEI	PARTMENT/PRO	OCESS	
	Rework	Skid-tube	Crosstube	٧	Vater Jet	Engineering
Part No.	Scrap	Machining	Small Fab	Prod. Er	ng. Coor.	Quality
	Use-as-is	Thermoforming	Finishing	Rec/Store/Page 1	ackaging	Other

Initial

Chief Eng

Large Fab

Composite

Sign &

Date

Action

Description

Supplier

Verification

QC Inspector

Work Order Update

Description of work order update

or Non-conformance

DOC, Data				1 1	
Equip/Tooling		•			
Operator					
Material _					
Setup 🚬			1	l i	
Other				·	
Process				1	
Supplier					
Training					
Unapproved					
			FAULT CATEGORY		
Landir	ng Gear	General			
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
[Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

NCR No.

Date

Step

Qty

Root

Cause Doc/Data

Work Orde				*106					Page 3			
Item ID: Revision ID:	D2938-1			Accept	*N900	040	100)*	Set	up Star	1.7	S1*
Item Name:	206 Saddle Le	eft side								Stop	*N	S2*
Start Date: Required Date: Reference:	8/30/13 9/20/13	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:						
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ite:			Ru	n Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty		Reject Qty	Reject Number	Insp. Stamp
155 SprayPaint Spray Fainting			per QSI 005 4.2 B <u>126</u> 5 side DELFLEET BLUE as 37					3		\$ _	Ø	13-10-14
	Jul	3-CLEAR V PRIME: Start Time:	with DELFLEET B 121 6:16 10:6:30	<u>703</u>								

165

QC14- Inspect Spray Paint

165

Quality Control

Memo

22 Sept

0.00 **DAS**27
9-89
0.00 |2 |0 |

											DQA:	Date	:		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE	QA Closed:	Date			
					· · · · · · · · · · · · · · · · · · ·	DISPOSITION				AGAINST DEPARTMENT/PROCESS					
Work Ord	er:					DISPOSITION	_		_	AGAINST DE	raniivilivi,	- FROCE33	_		
Part I	۷o.					Rework Scrap Use-as-is T			Skid-tube Crosstube Small Fab Thermoforming Finishing			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR I	No.					Work Order Update]	Large Fab Composite Supplier							
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data			i												
Equip/Tooling															
Operator															
Material															
Setup															
Other													,		
Process															
Supplier															
Training															
Unapproved		•													
						F	AUI	T CATE	GORY						
Landi	ng (Gear				General		_			_		_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Г	Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged	Г	Inspecti	on Incomplete		Part Incorre	ct	Weld		
	Г	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs				Contamination	Maintenance				Part Moved		_		
		Heat Trea	at			Countersink	Mislabeled Positioned Wrong								
	Г	Inspectio	n Strip in	Tube	e Cut Too Short Misread Power Loss/Surge Oth						Other				

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

QC

Quality Control

106453 Page 4 September-05-13 8:08:42 AM *N900040100* D2938-1 Accept Setup Start Item ID: **Revision ID:** Item Name: 206 Saddle Left side Start Qty: 3.00 **Cust Item ID: Start Date:** 8/30/13 Req'd Qty: 3.00 Required Date: 9/20/13 **Customer:** Reference: Run **Tooling:** Date: Process Plan: Date: Approvals: Stop SPC (Y/N): Date: Date: Reject Reject Sequence ID/ Tool ID Tool # Plan Accept Insp. Operation Set Up/ Number Stamp Work Center ID Description Code **Qty Qty Run Hours** Identify as per dwg & Stock Location: 57447 0.00 170 3x DAS 13-10-16 *170* 0.00 Packaging Memo Packaging 15/10-17 WB-10-17 180 QC21- Final Inspection - Work Order Release 0.00 *120*

0.00

Memo

										DQA:	Dat	:e:	
NCR:	es / N	ס		~	WORK ORDER NON-O	CONI	FORN	MANCE / UPDATE			_		
										QA Closed:	Dat	e:	
Work Orde	ar.				DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS		
Part N	lo		,	:	Rework Scrap Use-as-is Work Order Update	Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Supplier Large Fab Composite Supplier					Engineering Quality Other		
Root				Descri	ption of work order update	1	1	Action		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chie	f Eng	Description		Date	Verification	1	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other		3 E											
Process	<u> </u>	-											
Supplier													
Training													
Unapproved													
		<i>3</i> ,			F	AULT	CATE	GORY					
Landi	ng Gear				General	_				-	_		
	Bendir	ng			Bend		irain		L	Ovalized		Pı	ressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Ш	ardwa	re		Over/Under	tolerance	T•	emperature/Cure
	Cracks				Broken/Damaged	[]Ir	nspecti	on Incomplete		Part Incorred	t [\w	/eld
	Crushe	ed/Crimped			Burrs	lr	struct	ions Incomplete/Unclear		Part Lost/Mi	ssing	w	rong Stock Pulled
	Cuffs				Contamination	\square	/lainte	nance		Part Moved	_		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Picklist Print

September-05-13 8:08:41 AM

Work Order ID:

106453

Parent Item:

D2938-1

Parent Item Name:

206 Saddle Left side

Start Date: 8/30/13

3

Required Date: 9/20/13

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

	m r mone no per	114. 0 0. 00 1.											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	38.0000	1	3			
Saddle Billet, 7075										#1 (3 -0	9-14	
				Location		Loc Oty	<u>Le</u>	oc Code	4	1	, ,	r ()	
				MAT042		4				·-··			
•				103	592	4			_X	>			
				MAT045	-	34							
				975	663	34							

Page 1

		DQA:	Date:	
NCR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

								4			QA Closed:	Date	2:		
Work Orde	er:			•		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	•					Rework Scrap Use-as-is	The	Machining Sn		Crosstube Small Fab Finishing		Water Jet d. Eng. Coor.	Engineering Quality Other		
NCR N	No.				· ·	Work Order Update		Large F	_	Composite		Supplier			
Root					Descri	ption of work order update	Initial	Initial Action			Sign &				
Cause		Date	Step	Qty		or Non-conformance	Chief En	g	Des	cription	Date	Verification	QC Inspector		
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other								<i>.</i>							
Process						•									
Supplier							ŀ]	•			
Training															
Unapproved															
						F/	AULT CAT	EGORY							
Landi	ng (ear				General						_			
		Bending				Bend	Grain				Ovalized	L	Pressure/Forced		
		Centre No	t Concer	ntric to	o/s	BOM/Route	Hardy	/are			Over/Under	tolerance	Temperature/Cure		
		Cracks			<u> </u>	Broken/Damaged	Inspe	tion Inco	mplete		Part Incorred	 	Weld		
		Crushed/0	Crimped			Burrs	Instru	ctions Inc	omplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs Contamination					Contamination	Main	tenance			Part Moved				
	Heat Treat Countersink						Misla	peled			Positioned V	· ·			
	L.	Inspection	n Strip in	Tube		Cut Too Short	Misre	ad			Power Loss/	Surge	Other		
		Ripples in	Bend		<u></u>	Drill Holes	Offse								
		Torque W	aves in E	xtrusio	n 🗀	Drawing	Out o	Calibration	on						
		Turning S	equence			Finish	Out o	Sequenc	e ˙			<u></u>			
	Wave/Twist in Tube Folio					Outsi	de Dimens	ions							

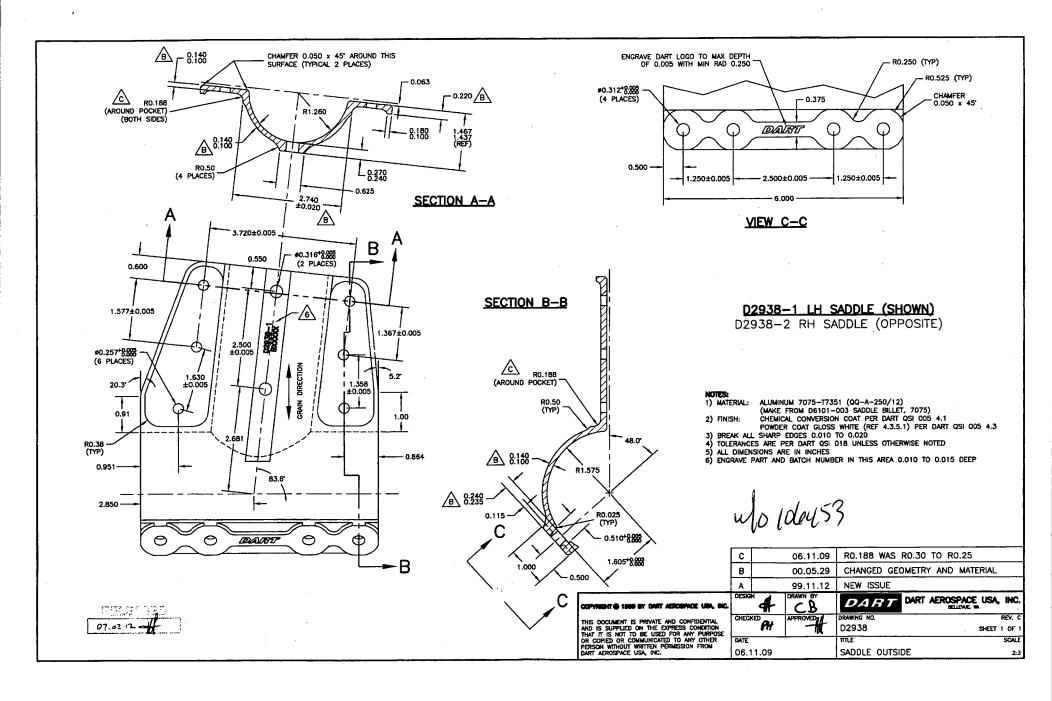
DART AEROSPACE LTD	Work Order:	100435
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

	Recorded Actual Dimensions								
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		2115	-115	.113	.110		
В	0.100	0.140		-116	115	.110	.(10		
С	0.100	0.140		1117	مالاه	e [[[.115		
D	0.210	0.230		,225	·274	.223	,227		
Е	1.245	1.255		1.250	1.290	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	513	.5/3	.513		
1	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		250	, 260	.260	.260		
L	0.312	0.317		323	315	315	.315		
М	0.235	0.240		-238	.238	. 238	, 23'%		
N	0.100	0.140		120	-119	.116	118		
0	0.540	0.560		.550	551	.450	.550		
Р	0.490	0.510		.497	.497	.500	.501		
Q	3.715	3.725		3720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.440		
S	0.240	0.270		1.254	.2,52	.252	1252		
Ť	0.100	0.180		140	.145	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.830		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		318	.318	-318	.318		
X	1.250	1.270		1,260	1.262	1.261_	1.260		
Y	1.565	1.585		1.576	1.577	1.576	1.575		
Z	0.178	0.198		-186	. (8°C	.188	.186		
AA				\\A\					
AB									
AC									
AD				2					
AE				127					
AF				3		Ī			
AG				N					
AH									
	Ac	cept/Reje	ect						

		٨	24.0
Measured by: 2.T	Audited by	M.A.	() ()
Date: 13 09 - 16	Date:	13/09/14	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \

Date	Change	Revised by	Approved
	New Issue	RF	
02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
07.03.21	Revised per drawing revision C	KJ/JLM X	GH .
	02.12.12	New Issue 02.12.12 Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	New Issue RF 02.12.12 Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 KJ/RF



DQA:	Date:		

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: **DISPOSITION AGAINST DEPARTMENT/PROCESS** Work Order: Engineering Skid-tube Crosstube Water Jet Rework Quality Machining Small Fab Prod. Eng. Coor. Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Supplier NCR No. Work Order Update Large Fab Composite Description of work order update Action Sign & Initial Root Chief Eng Date Verification QC Inspector Date Step Qtv or Non-conformance Description Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Grain Ovalized Pressure/Forced Bending Bend BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Inspection Incomplete Weld Cracks Part Incorrect Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Contamination Cuffs Maintenance Part Moved Countersink Mislabeled **Positioned Wrong** Heat Treat Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Ripples in Bend **Drill Holes** Offset Torque Waves in Extrusion Drawing **Out of Calibration Turning Sequence** Finish **Out of Sequence** Folio Wave/Twist in Tube **Outside Dimensions**

NCR:

Yes / No